Page 1

Item ID:

D120-638-011

Accept

Setup Start

Stop

**Revision ID:** Item Name:

**Start Date:** 

Bearpaw

1/19/10

Start Qty: 4.00 Req'd Qty: 4.00

Date:

**Cust Item ID:** 

**Customer:** 

Reference:

**Process Plan:** Approvals:

Required Date: 1/25/10

QC:

Date: 10-1-19

0.00

SPC (Y/N):

Date:

Date:

Run

Start Stop

Sequence ID/ Work Center ID

**Operation** Description

Set Up/ **Run Hours**  Draw Number

Plan Draw Rev. Code

Accept Oty

Reject Qty

Reject Number Stamp

Insp.

**Draw Nbr** 

**Revision Nbr** 

D2435

Rev E1

100

DOCUMENT CONTROL

Document Control

Memo

Photocopy bluefile and create labels per PPP D120-638-011 CHG 002

160

Packaging Packaging

Pick Kit

Memo

0.00

0.00

10-1-20

170

QC

**Quality Control** 

Memo

QC4-100% Inspect kits for completeness

Dart Aerospace Lt
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W/O:			W	ORK ORDER CHANG	ES		* *		<u> </u>	
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- Andrew Senant				19 No. 10 Pt. 10						
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DATE	STEP	Description of NC		Corrective Action Secti		Verifi	cation	Approval	Approval	
- DAIL	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector	

## Work Order ID 55471

January 19, 2010 12:43:01 PM

Item ID:

D120-638-011

Accept

Accept

Qty \_\_\_

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Required Date: 1/25/10

Item Name:

Bearpaw

1/19/10

QC:

Start Qty: 4.00

**Req'd Qty:** 4.00

Cust Item ID:

**Customer:** 

Draw

Number

Reference:

Approvals:

**Process Plan:** 

**Tooling:** 

SPC (Y/N):

Date:

Date:

Draw

Rev.

Plan

Code

Run Start

Reject

Qty

Stop

Reject

Number

Insp.

Stamp

Sequence ID/ **Work Center ID** 

180

Packaging

Quality Control

Packaging

190

Operation Description

Packaging

Set Up/ **Run Hours** 

Date:

0.00

0.00

Identify and pack of shipping as per PPPD120-638-011

Location:

Memo

0.00

QC21- Final Inspection - Work Order Release

Memo

0.00

10 (01) 25° MF 10-1-25

## **Dart Aerospace Ltd**

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DATE	STEP	Description of NC		<del></del>	etion B	Verifi	cation	Approvai	Approval
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	1		-						

Picklist Print January 19, 2010 12:43:6	06 PM	·			Page 1
IPP F	paw Rev:A New Issue 07-01-02 Rev:B Added Step 2 08-04-10	JLM  JLM Verified By:EC acturing Method JLM Verifi	ed By:EC	Start Date: 1/ Start Qty: 4.	•
Component Item ID/ D2435 +2  Bearpaw, 206	Replacement Mfg/ Manufactured	Bin Primary Last No	Route Unit of 160 Each	0.0000 8.0000	B55472 *8 15754Sf
D2182B050 + Clamp Cushion Black	Manufactured  Manufactured  Manufactured	1/2/	160 Each	0.0000 16.0000	10-1-20 \$ 52649
D2274 LE Radius Block	Manufactured	No	160 Each	139.0000 32.0000	10-1-00
		Warehouse Location  Main Warehouse ST010 52644  Main Warehouse ST10	Loc Oty 41 41 98	<u>Loc Code</u>	32
D2438 74 Clamp	Manufactured	No S4850 Warehouse	98 160 Each  <u>Loc Oty</u>	76.0000 16.0000	10-1-00 50 (4x

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
ST	76		
46113	5		48.4
53221	71		10

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DATE	STEP	Description of NC				Section B Ve			Approval	Approval
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January 19, 2010 12:43:06 PM

Work Order ID: 55471

Parent Item:

**Comments:** 

D120-638-011

Parent Item Name:

Bearpaw

New Issue 07-01-02 JLM IPP Rev:A

**Start Date: 1/19/10** 

Required Date: 1/25/10

Start Qty: 4.00

Required Qty: 4.00

No   No   No   No   No   No   No   No	74	Component Item ID/ D2529 ( )	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 160	Unit of Each	<b>Qty on</b> 730.0000	Remaining 32.0000	Qty 10-1-20	Date	Status
Warehouse   Loc Qty   Loc Code	S <sub>M</sub>	ana.15a &8		Purchased	No	<u>Loca</u> Main Wa	urehouse		730 730				sf	
T\ wasner		AN960JD416 <b>\</b>		Purchased	No	<u>Loca</u> Main Wa	113121 113538		602 6 400 196				<b> s</b>	4

Location Main Warehouse 149 ST \_ 149 0

Dart Aerospace Ltd
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	R	esolution:	Dispositio	_ QA: N/	QA: N/C Closed: Date:					
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DATE	STEP	Description of NC Section A	Initial	Action Description		gn &		cation ion C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 55471

D120-638-011

Parent Item Name:

Component Item ID/

Parent Item:

Comments:

Bearpaw IPP Rev:A

New Issue 07-01-02 JLM

IPP Rev:B

Added Step 2 08-04-16 JLM Verified By:EC

IPP Rev:C

08-10-15 New Manufacturing Method JLM Verified By:EC

Replacement Mfg/

Purchased

Bin Primary No

Last

Route 160

Unit of Each

Qty on 3,709.000 32.0000

Remaining

Qty

**Start Date: 1/19/10** 

Start Qty: 4.00

Date

Required Date: 1/25/10

Required Qty: 4.00

Status

MS21042L4 19

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse			
ST	3709		
102552	. 6		
104248	6		
110507	184		
111827	2513		32
113422	1000		
15924	0		

Dart Aerospace L	td
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W/O:			WO	RK ORDER CHANGI	ES		·	<del> </del>	<del>, (*</del>
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				12					
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b> /	\ <b>\</b> :	Date: _	
Resolution:									
NCR:		•	WORK ORDE	R NON-CONFORMA	NCE (NCF	R)		•	
DATE	STEP	Description of NC	Corrective Action Section B			Verificati		n Approval	
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# REFERENCE ONLY



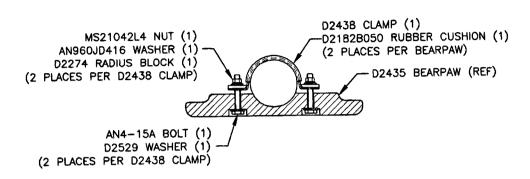


Figure 2 - Bearpaw Installation

### 4. WEIGHT AND BALANCE

		LAT	ERAL	LONGITUDINAL		
Installation	Weight	Arm	Moment	Arm	Moment	
D120-638-011 Bearpaw	8.4 lb	0.0 in	0.0 in-lb	178.7 in	1501.1 in-lb	
	3.82 kg	0.0 m	0.0 m-kg	4.54 m	17.34 m-l	

#### 5. PARTS LIST

Part Number	Description				
D120-638-011	BEARPAW INSTALLATION	-,			
D2182B050	Rubber Cushion				
D2274	Radius Block				
D2529	Washer				
D2435	Bearpaw				
D2438	Clamp				
AN4-15A	Bolt				
AN960JD416	Washers				
MS21042L4	Nut (or MS21042-4)				
	D120-638-011  D2182B050 D2274 D2529 D2435 D2438  AN4-15A AN960JD416	D120-638-011         BEARPAW INSTALLATION           D2182B050         Rubber Cushion           D2274         Radius Block           D2529         Washer           D2435         Bearpaw           D2438         Clamp           AN4-15A         Bolt           AN960JD416         Washers			

Revision: A

Date: 99.07.07

## **Dart Aerospace Ltd**

W/O:			WC	ORK ORDER CHANGI	ES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:					
	Re	esolution:	Dispositio	n:	QA: N/C Closed:			Date:		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCI	₹)				
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			Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector	
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